

Date: Monday, 2/19/2007 3:26:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR LH
Job Number : 30768	
Estimate Number : 11226	
P.O. Number : N/A	Part Number : D32801
This Issue : 2/19/2007 S.O. No. : N/A	Drawing Number : D3280 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 25747	Material : N/A
Written By : _____	Due Date : 3/15/2007 Qty: 10 Um: Each
Checked & Approved By : <u>07.02.19</u>	
Comment : Est Rev: A 04.07.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3136C207102121

(10)

Description: Floor Protector RH

Possible Supplier: Delastek

Certificate of Conformity is required

2.0	D32801P	Floor Protector, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Floor Protector, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Pc 7/3/22

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

07.03.29

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pc 7/3/30 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/04/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 3:26:53 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR LH

Job Number: 30768

Part Number: D32801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

2/10/07/04

Job Completion



U 07-04-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

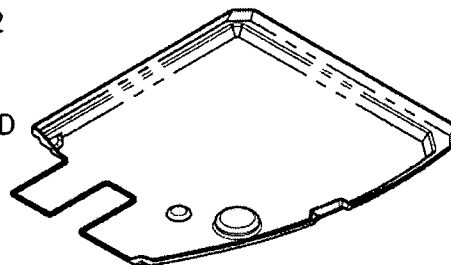
NOTE: Date & initial all entries



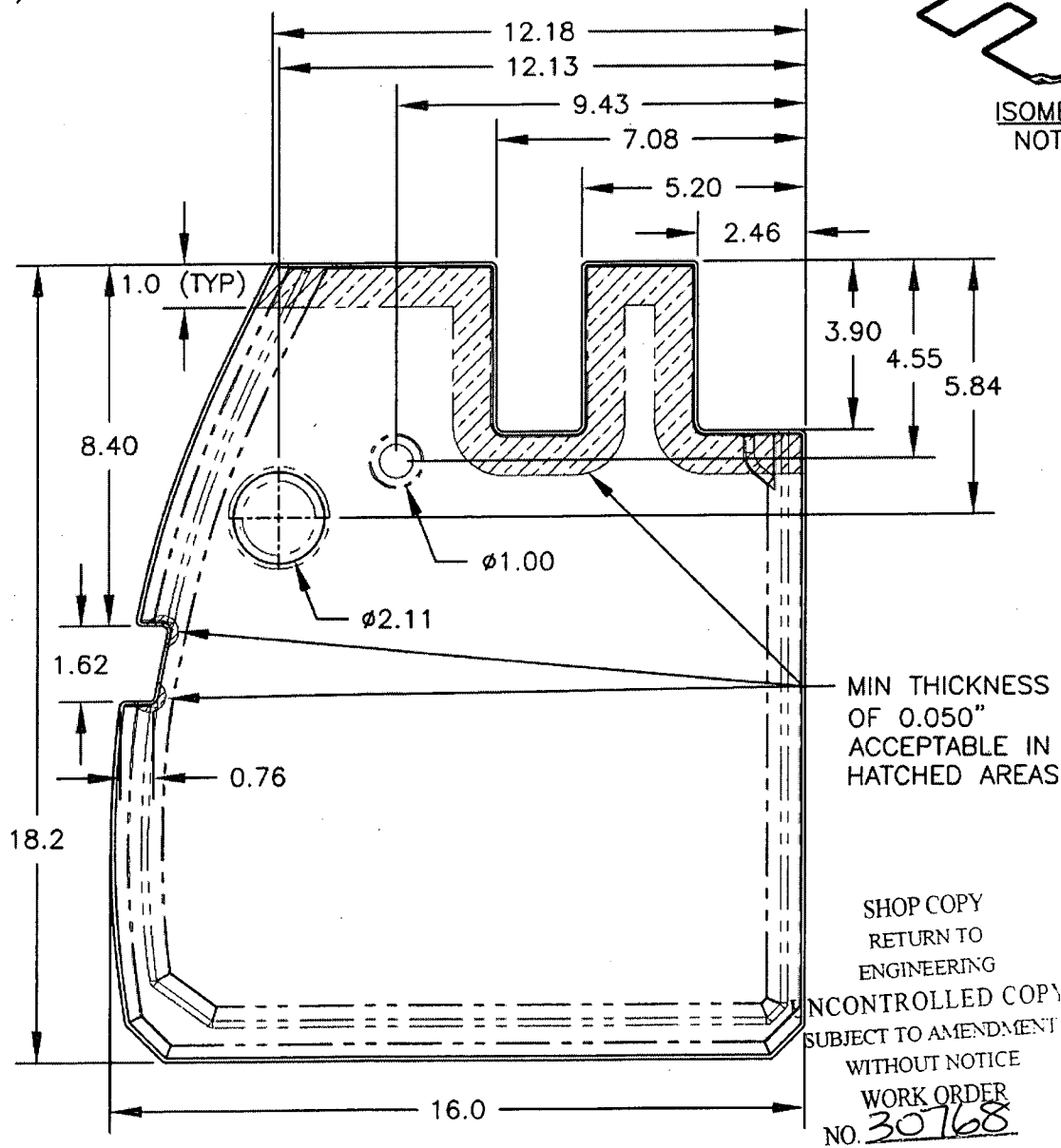
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3280	REV. B SHEET 1 OF 2
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:4
A	04.04.05	NEW ISSUE	
B	05.11.25	NOW LEXAN, DIMS AS MANUFACTURED	

D3280-1 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-1T1, TRIM USING D3280-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN



ISOMETRIC DETAIL
NOT TO SCALE



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NO. 30768

RELEASED
05-12-01

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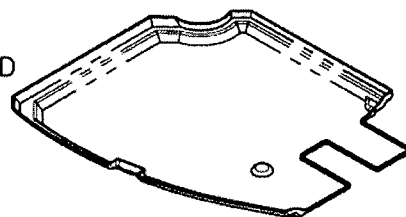
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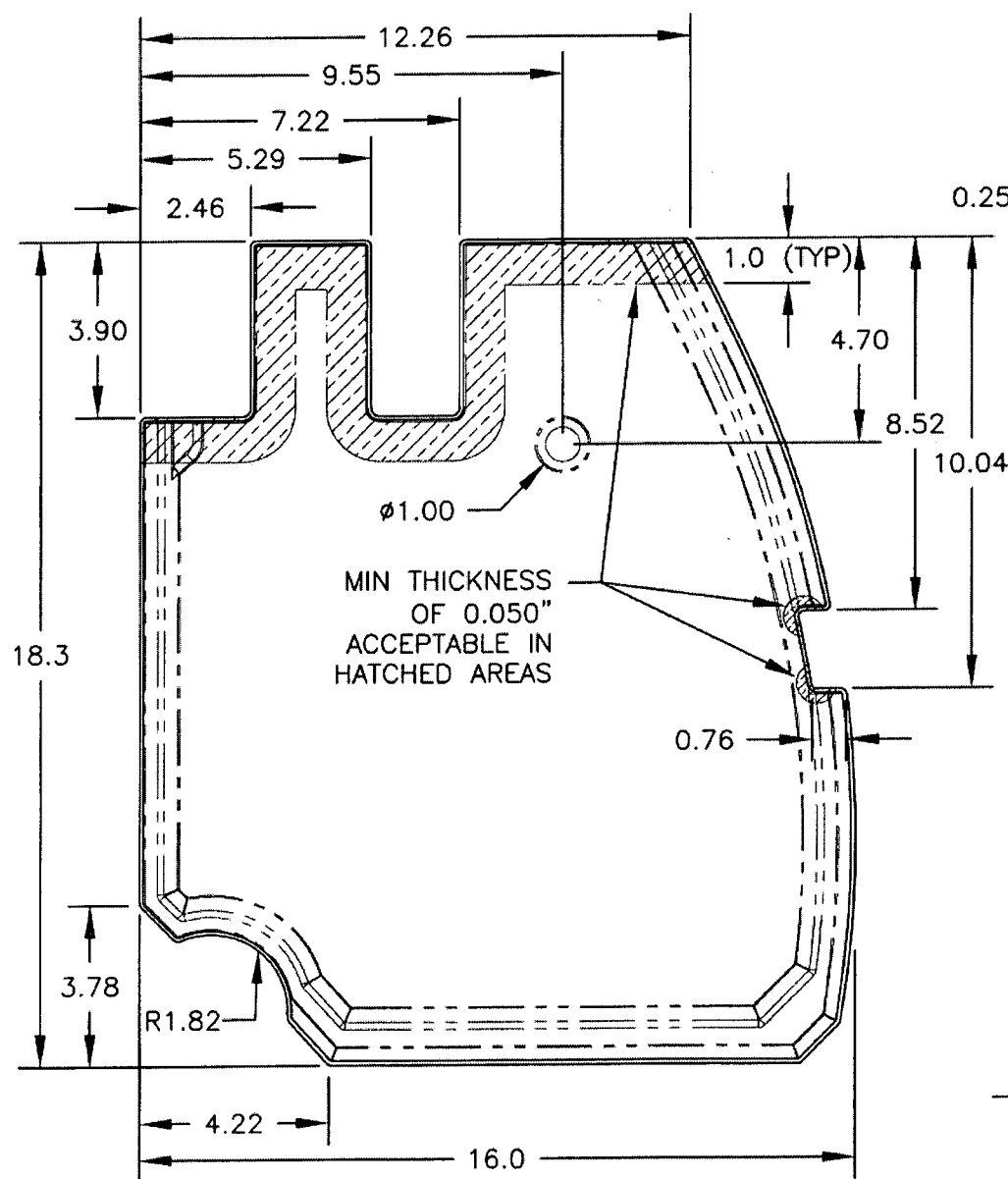
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3280	REV. B SHEET 2 OF 2
DATE 05.11.25		TITLE FLOOR PROTECTION	SCALE 1:4

D3280-3 FLOOR PROTECTOR

- 1) THERMOFORM USING MOLD D3280-3T1, TRIM USING D3280-3T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080 EXCEPT AS SHOWN



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05-12-01

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11735
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
16/03/07	21/02/07	5175	C. Lavoie	PO00003136			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
10	0	10	DKC134-0048	Floor Protect LH N° D3280-1P (F6006) Selon dessin D3180 Rev.: B Dart Aerospace JOB: 41080 QTÉ: 10			
10	0	10	DKC134-0049	Floor Protect RH N° D3280-3P (F6006) Selon dessin D3180 Rev.: B Dart Aerospace JOB: 41081 QTÉ: 10			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by

Quality department

AQ-357



Lundi, 2007-02-26 10:49:55

atour: Sylvie Hamel

Feuille de Procédé

nt : DART Dart Aerospace Ltd.
méro Job : 41080
méro Soumission : 2387
méro B.A. :
tte fois : 2007-02-26 No. B.V. :
iht Rev. : NC
m. fois : - - Type :
b précédente : 41068
rit par :
rifié & Approuvé par :
mmmentaires : N° de pièce: D3280-1

Nom Dessin : FLOOR PROTECTOR
Numéro Article : DKC134-0048
Numéro Dessin : D3280
Projet Numéro : DKC134
Révision dessin : B
Matériel : F6006
Date Due : 2007-03-02

Qté: 12 Udm: UNITE



10.03.07

Process Sheet Rév.: 00 Création du premier

oduit additionnel

uméro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Total : 2.004 UNITE(s)
Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot: 1-5913-1

2.0	SÉCHAGE/ ANEAL	SÉCHAGE / ANEALING
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Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.4000Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.
Inscrire sur la charte de température le numéro de Job du matériel au séchage.
de cuisson: 5543

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 36.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.




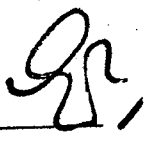








Quantité: 12 Date: 8-3-07 Sceau:

Quantité: Date: Sceau:



Re: Lundi, 2007-02-26 10:49:55
Émetteur: Sylvie Hamel

Feuille de Procédé

Client:	DART Dart Aerospace Ltd.	Nom Dessin:	FLOOR PROTECTOR
Numéro Job:	41080	Numéro Article:	DKC134-0048
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
4.0	THERMOFORMAGE2 	THERMOFORMAGE DES PIÈCE DART 	
Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.0000Hrs THERMOFORMAGE DES PIÈCES Faire le thermoformage du " Floor Protector " N° D3280-1 à l'aide du moule N° D3280-1T1 sur le thermoformeur 4' x 8'. Autocontrôle du lot de pièce thermoformées. Quantité: <u>12</u> Date: <u>8-3-07</u> Sceau:  Quantité: _____ Date: _____ Sceau: _____			
5.0	TRIMAGE 3 	TRIMAGE COMPOSITES DART 	
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.0000Hrs TRIMAGE PLASTIQUE DART Faire le trimage du " Floor Protector " N° D3280-1 à l'aide du gabarit de trimage N° D3280-1T2. Faire l'ébavurage des pièces. Autocontrôle du lot de pièce trimées. Quantité: <u>12</u> Date: <u>14-3-07</u> Sceau:  Quantité: _____ Date: _____ Sceau: _____			
6.0	INSPECTION 3 	INSPECTION PIÈCE DART 	
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs INSPECTION PIÈCE DART Faire l'inspection finale des pièces selon le dessin. Quantité: <u>10</u> Date: <u>15-3-07</u> Sceau:  2 Rejets RNC #1211			
7.0	IDENTIFICATION4 	IDENTIFICATION PIÈCES DART 	
Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs IDENTIFICATION PIÈCES DART Faire l'identification des pièces à l'aide des informations suivantes:			

Date: Lundi, 2007-02-26 10:49:55
Imprimé par: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41080

Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0048

Numéro Job:



Séq.:

Machine ou Opération:

Description :

N° de pièce: D3280-1

N° de Job: 41080

Date de fabrication: 14-3-07

Sceau d'inspection:

formation CR

Quantité: 12 Date: 14-3-07 Sceau: CM

Quantité: 10 Date: Sceau:

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.0000Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3280-1

Date de fabrication:

N° de job:

Quantité: 12 Date: 15/3/07 Sceau: 11

Quantité: 10 Date: Sceau: